

Date: Tuesday, 12/20/2005 2:50:25 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT
Job Number : 25296	
Estimate Number : 11046	
P.O. Number : N/A	Part Number : D2814
This Issue : 12/20/2005 S.O. No. : N/A	Drawing Number : D2814 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 1/15/2006
Checked & Approved By : <u>SEE ABOVE USER</u>	Qty: 10 Um: Each
Comment : Est. C 02.06.18 Added finishing level (Ref. ECN 435) KJ	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TR0500W035	304 RD Tube .500 x .035W
-----	----------------	--------------------------



Comment: Qty.: 2.1000 f(s)/Unit Total : 21.0000 f(s)

304 RD Tube .500 x .035W

Punch 304/316 SS Seamless Tubing 0.5" O.D. x 0.035" wall to length as per Dwg D2810 and spec control

Dwg D2727 using Jig DT8012

Batch: ~~M19400~~ M19400

FF 06-01-26 10

2.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Length as per Dwg D2810 and spec control Dwg D2727 using Jig DT8012

2-Deburr

DL 06-01-27 10  
FF 06-01-26 10

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

06-01-31 10

4.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

a.m 06-02-16

10

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	-----------------------------------------



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M1

06 02 16

1-0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.01.12	2	STRUT Hole offset, because Bolt in Jig 8612 broken	<i>[Signature]</i>	Destroyed struts total length app. 60" replace	TF 06.01.12	<i>[Signature]</i> 06.02.20	<i>[Signature]</i>	<i>[Signature]</i>

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 2:50:25 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 25296

Part Number: D2814

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 388

*PU 6/2/17 (10)*

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*SHE 06/22/20 (20) DP 06/22/20 (10)*

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

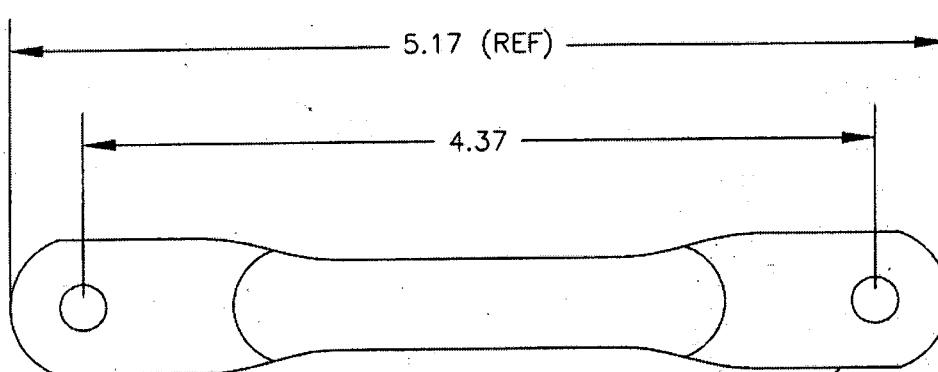
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <b>KE</b>	DRAWN BY <b>KE</b>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>[Signature]</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D2814	REV. A SHEET 1 OF 1
DATE 99.09.29		TITLE STRUT	SCALE 1:1
A	99.09.29	NEW ISSUE	
AI	<del>CP</del> 02.03.26	ADD FINISH	

RELEASED  
99.10.12 KE



PUNCH ENDS PER SPEC  
CONTROL DRAWING D2727

SHOP COPY  
RETURN TO  
ENGINEERING  
COPY  
FILE

NOTE:  
MATERIAL: 304/316/318 SS, 0.50 OD x 0.035 WALL,  
ENSURE SEAMLESS TUBING IS USED  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QOS 4.3 **AI**

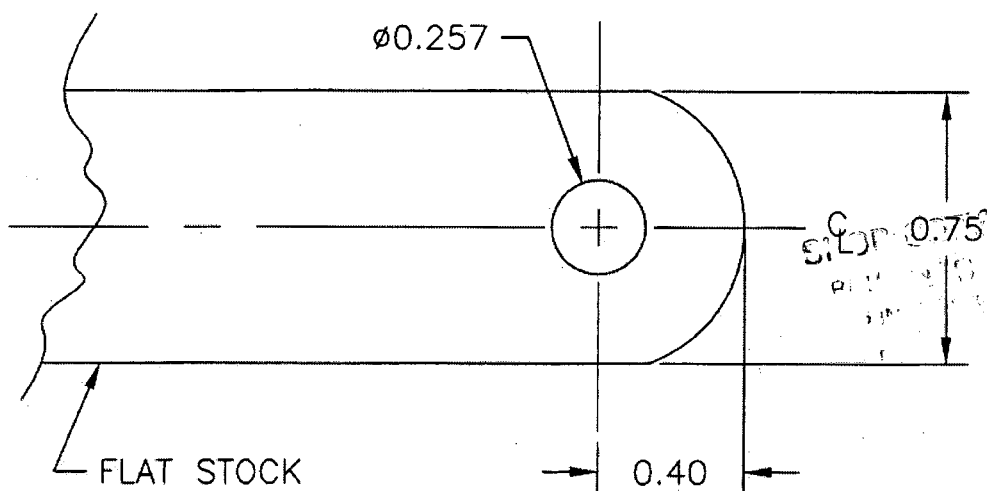
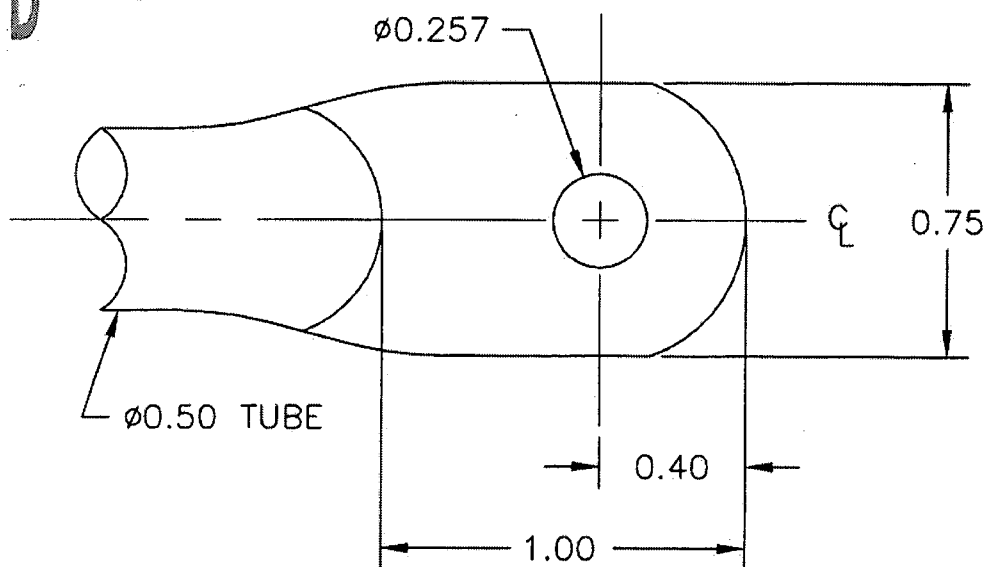
252916



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED MAY	APPROVED CA	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	FCP 01.12.20	ADD TOLERANCE NOTE	

## SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED  
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



25296